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D5627-1
Job Sheet 193681



Part No: D5627-1

Job Qty: 12 pcs

Part Name: Tube



Part Weight: 0 lbs

Job Created: 4/18/19

Due Date: 4/29/19

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: D5627 REV.B IPP REV:A 18.04.04 NEW ISSUE DD VERF:JFS IPP REV:B 18/08/03 AS PER DWG REV.B
JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	12 pcs	4/29/19		0.00	3.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		ML
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
120	QC 5	12 pcs	4/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		GL
							QC 5 - 30		
							QC 5 - 40		
123	Conventional Mill - 1 - B4B	12 pcs	4/29/19		0.00	3.00	Conventional Mill - 1 - B4B		
							Conventional Mill - 2 - B4B		19/5/17

QC 5	12 pcs	4/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
130 Small Fab - 2 - B4B	12 pcs	4/29/19	0.00 2.40	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
135 QC 2	12 pcs	4/29/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
136 QC 8	12 pcs	4/29/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	

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				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
QC 8 - 23					
140 Handfinish - 1-1 Chemical-B4B	12 pcs	4/29/19	0.00 1.20	Handfinish - 1 - 1 - B4B	BERM-05-02
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	12 pcs	4/29/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	2019 MAY 09 10:37 AM
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
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					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
160 Packaging 3-1 - Stock - B4B	12 pcs	4/29/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B	DAS 28 9-89	
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
170 QC 21 - SA	12 pcs	4/29/19	0.00 0.00	QC 21 - SA - 21	DAS 21 MAY 09 2019 9-89	
				QC 21 - SA - 70		
				QC 21 - SA - 53		
Part Op 110 - (Fabricate per Drwg) 1- CUT BLANKS at 14.00" 2- BEND AS PER DWG WITH Baileigh Hydraulic CNC Bender Descriptions: using D-1500T-R400-E Die Set. Bend @ 102 degrees on bender to achieve 90. USE DT _____ AS A TEMPLATE. SCRIBE ENDS FROM THE EDGE OF TEMPLATE AND CUT TO SIZE. 120 - (QC5- Inspect part completeness to step on W/O) 123 - (Manufacture as per dwg) CHAMFER ONE INSIDE END OF TUBE AS PER DWG 126 - (QC5- Inspect part completeness to step on W/O) 130 - (Small Fab) DRILL HOLES AS PER DWG AND DEBURR (DT10423) AND BUFF ALL BEND MARKINGS 135 - (QC2- Inspect parts off machine FAI/FAIB) 136 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (QC7-Inspect Chemical Conversion Coat)						

160 - Identify as per dwg & Stock Location: ***GA***
170 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6T1.500W.125	6061T6 Round Tube 1.50 X .125W	14.0400 ft (1.17 ea)	110-Large Fab - Welded Assy-1	5068/8
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	M6061T6T1.500W.125	14	43	0
Part Specifications				
Specifications could not be found.				

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DQA: _____ Date: _____

QA Closed: **DAS 53** Date: **JUN 14 2019**

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: 193681		Step #: 1 (OP# 110)		QTY Effective: 1		MRB (Q51042) Approval D 17-08-07			
Part No. D5627-1		Rework ☐ Scrap ☒ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☒		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐			
NCR No. 19-7129		Suspected Unapproved ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☒		Engineering Quality ☐ Other ☐			
Date: 19/5/7		Description Work Order Deviation		Disposition					
Finish dimension on one side should be 7.27"		Operation to make sure that part is properly seated in JLG- before cutting to length.				Completed By [Signature]			
Was cut too short by 0.100" making straight portion too short that impervible to insert D5499 and would be too short at final assembly making it out of tolerance.						Lead hand / Supervisor Approval Verification ankal0507			
						QC / QA Coordinator Approval DAS 68 9-89 MAY 07 2019			
Root Cause		FAULT CATEGORY							
Environment ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Design ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐	
Doc/Data ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐	
Equip/Tooling ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐	
Handling/Pre ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Material ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐	
Internal Transport ☐		Crushing ☐		Countersink ☐		Off-set ☐		Drawing ☐	
Tribal Knowledge ☐		Heat Treat ☐		Cut Too Short ☒		Mislabeled ☐		Finish ☐	
LOA ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐	
Substation ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐	
Past Expiry Date ☐									
Misidentified ☐									
		OTHER: ☐							